

Work Order ID 121637

121637

Page 1

Thursday, June 26, 2014 3:05:18 PM

Item ID: D4881-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: 206A/B AFT Leg Assembly, RH
 Start Date: 6/26/14 Start Qty: ~~9.00~~ ***3*** Cust Item ID:
 Required Date: 6/26/14 Req'd Qty: 3.00 ***3*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 4-06-30 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4881	<u>B</u> <u>Cu</u>								

110

0.00

110

Small Fab

0.00

Small Fab

Memo

ALIGN PILOT HOLES IN D4881-1 WITH PILOT HOLES IN D4885-2 AND D4885-3. DRILL OUT EACH HOLES USING A PILOTED DRILL AS PER DWG.
 REAM EACH HOLES USING REAMER, USING DART TOOL SETUP DT9974 AS PER DWG.

2 FF DEC 01 2014

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

(2) DAS
38
9-89

DEC 01 2014

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge		
☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Doc/Data									
Equip/Tooling									
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* Work Order ID 121637

Thursday, June 26, 2014 3:05:18 PM

121637

Page 3

Item ID: D4881-042

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: 206A/B AFT Leg Assembly, RH

Start Date: 6/26/14 Start Qty: 3.00

3

Cust Item ID:

Required Date: 6/26/14 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Receive & Inspect for Damage & Mat'l Certs	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89
170									
QC	Memo	0.00							
Quality Control									
180	Identify as per dwg & Stock Location: 4135	0.00							
180									
Packaging	Memo	0.00							
Packaging									

JAN 08 2015

DAS
38
9-89

2x 8015-01-7

(2)

2 CR 15-01-08

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Doc/Data									
Equip/Tooling									
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Training									
Transport									
Unapproved									

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121637

Page 4

Item ID: D4881-042

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: 206A/B AFT Leg Assembly, RH

Start Date: 6/26/14 Start Qty: 3.00

3

Cust Item ID:

Required Date: 6/26/14 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21 - Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

MLJ 15-01-09

MF
15-01-09

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

Thursday, June 26, 2014 3:05:17 PM

Page 1

Work Order ID: 121637

121637

Parent Item: D4881-042

D4881-042

Parent Item Name: 206A/B AFT Leg Assembly, RH

Start Date: 6/26/14

Required Date: 6/26/14

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP REV:A 13.12.17 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4881-1		Manufactured	No		121690		Each	0.0000		3			
D4881-1									**	2	FF	DEC 01 2014	
Strut													
D4885-2		Manufactured	No		121688		Each	2.0000		3			
D4885-2									**	1	FF	DEC 01 2014	
End Fitting													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST126		1							
					116572	1				2			
				ST139E		1							
					112033	1							
D4885-3		Manufactured	No				Each	4.0000		3			
D4885-3									**		FF	DEC 01 2014	
End Fitting													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST139A		4							
					112034	4				2			
HL20PB5-12		Purchased	No				Each	180.0000		12			
HL20PB5-12									**		FF	DEC 01 2014	
Rivet													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST265	129912	180				8			
				M128110		38							
				M128973		142							

HL20PB5-12

HL20PB5-12

Rivet

HL32PB5-12

u

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

Page 2

Thursday, June 26, 2014 3:05:17 PM

Work Order ID: 121637

121637

Parent Item: D4881-042

D4881-042

Parent Item Name: 206A/B AFT Leg Assembly, RH

Start Date: 6/26/14

Required Date: 6/26/14

Start Qty: 3.00

Required Qty: 3.00

HL86-5

Purchased

No

Each

241.0000

12

HI 86-5

FF

DEC 01 2014

Collar

Location

Loc Qty

Loc Code

ST263

129064

241

M128110

12

M128228

29

M129022

200

8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO26707**

Purchase Order Date 12/3/2014

PO Print Date 12/3/2014

Page Number 5 of 6

Order From :

VC-PL001

P & L PRINTING
19226 AIRPORT ROAD
SUMMERSTOWN, ONTARIO K0C 2E0
CANADA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

613-931-1241

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Total:

\$8.

13 121097

D4881-041 LEG
ASSEMBLY

12/5/2014

1.00

\$4.00

\$4.

Yes

12/5/2014

LASER MARKED

Line Total:

\$4.

14 121637

D4881-042 LEG
ASSEMBLY

12/5/2014

2.00 ✓

\$4.00

\$8.

Yes

12/5/2014

LASER MARKED

SP15-01-7

Line Total:

\$8.

15 71401-45

PROCUREMENT
QUALITY CLAUSES

12/5/2014

1.00

\$0.00

\$0.0

No

12/5/2014

Quality Procurement Clauses

A005 RIGHT OF ENTRY

A016 PERSONNEL QUALIFICATION

A042 DART NOTIFICATION BY SUPPLIER

Note:

12/3/2014



19226 Airport Road
Summerstown, ON
K0C 2E0 Canada

Tel. 613-931-1241
Fax 613-931-2560
plprinting@bellnet.ca

PACKING SLIP

SOLD TO

DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

SHIPPED TO

DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

DATE Dec 22, 2014

P.O NUMBER P026707

ITEM DESCRIPTION**QUANTITY****COMMENTS**

D4802-041 LEG ASSEMBLY 2 ALL ITEMS HAVE BEEN LASER MARKED

D4804-041 BIPOP ASSEMBLY 1

D4834-041 LEG ASSEMBLY 2

D4835-041 LEG ASSEMBLY 4

D4836-041 LEG ASSEMBLY 2

D4836-041 LEG ASSEMBLY 2

D4866-041 LEG ASSEMBLY 1

D4866-042 LEG ASSEMBLY 1

D4866-042 LEG ASSEMBLY 1

D4867-041 LEG ASSEMBLY 2

D4878-041 LEG ASSEMBLY 2

D4880-041 LEG ASSEMBLY 2

D4881-041 LEG ASSEMBLY 1

D4881-042 LEG ASSEMBLY 2

SP 15-01-7